

Work Order ID 61969-1

PRELIMINARY ISSUE



Page 1

Monday, September 13, 2010 11:16:41 AM

Item ID:	D4173-7	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Radalt Shim					
Start Date:	9/13/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	9/20/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date: 10-9-13	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4173	PA1 PA2								
100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet	Memo CUT AS PER DWG PROG REV: PA2 DWG REV: PA2 DEBURR								
110		0.00							
QC		0.00							
Quality Control									

10-9-14

10-9-14

Photo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4173-7 PAR #: _____ Fault Category: Small Eng-design NCR: Yes No DQA: ✓ Date: 10-10-01
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 10/10/01

NCR: <u>61969</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-09-15	120	2 parts SCRAP DUE TO ENG. CH Design CHANGE R C: other	<u>10-09-15</u>	SCRAP? Replace. w/le. Rev PAR.	<u>10-09-15</u>	<u>10/09/15</u>	<u>10-09-15</u>	<u>10/09/15</u>

NOTE: Date & initial all entries

Work Order ID 61969

Monday, September 13, 2010 11:16:41 AM



Page 2

Item ID: D4173-7	Accept		Setup Start	
Revision ID: PRELIM			Stop	
Item Name: Radalt Shim				
Start Date: 9/13/2010	Start Qty: 2.00		Cust Item ID:	
Required Date: 9/20/2010	Req'd Qty: 2.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HAAS 1		0.00							
HAAS CNC vertical machine #1	Memo MILL AS PER DWG AND FOLIO FA 961 FOLIO REV: <i>PA-FA</i> DWG REV: <i>Rad</i> DEBURR	0.00							<i>Jul 10.09.15</i>
130 QC		0.00							
Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00							<i>Jul 10.09.15</i>
140 QC		0.00							
Quality Control	QC8- Inspect parts - second check Memo	0.00							<i>inspected to PA2 Dry only 8/10/2015 (x2)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Item ID: D4173-7	Accept		Setup Start	
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Item Name: Radalt Shim				
Start Date: 9/13/2010	Start Qty: 2.00		Cust Item ID:	
Required Date: 9/20/2010	Req'd Qty: 2.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location:	0.00							
	Packaging								
Packaging	Memo	0.00							
160	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

10/09/29
W10.09.23

POSITIVE RECALL
EFFECTIVE 10.09.13
RELEASED
AUTH
DATE 10.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 11:16:45 AM

Page 1

Work Order ID: 61969

Parent Item: D4173-7

Parent Item Name: Radalt Shim



Start Date: 9/13/2010

Required Date: 9/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-09-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB625		Purchased	No			100	sf	9.0000	0.5	1.052632			



UHMW .625 Black Tivar 1000



1310-9-12

Location

Loc Qty

Loc Code

MAT

9

109313

9

109313

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

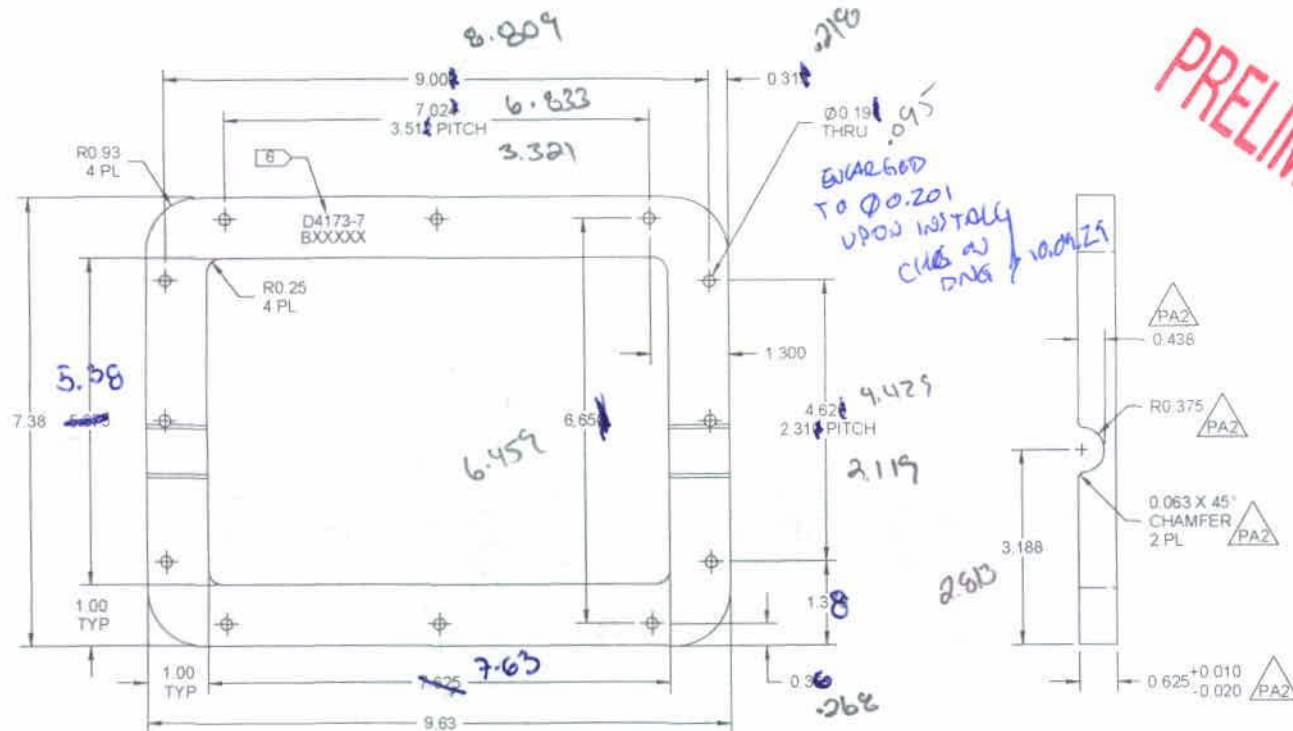
DART AEROSPACE LTD		Work Order: 61969
Description: RADALT Shim		Part Number: D4173-7
Inspection Dwg: D4173-7 Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+ .005 - .001	.193	*			
9.000	+/- .030	9.004	*			
7.024	+/- .030	7.022	*			
3.512	+/- .030	3.510	*			
.313	+/- .030	.315	*			
1.300	+/- .030	1.304	*			
4.626	+/- .030	4.618	*			
2.310	+/- .030	2.313	*			
1.378	+/- .030	1.383	*			
.363	+/- .030	.368	*			
9.63	+/- .030	9.635	*			
7.625	+/- .030	7.615	*			
1.00	+/- .030	1.010	*			
5.375	+/- .030	5.373	*			
7.38	+/- .030	7.386	*			
.625	+ .010 - .010	.607-.628	✓			
.438	+ .010 - .010	.438	✓			
R.750	+/- .010	R.750	✓			

Measured by: <i>B. J. [Signature]</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 10-9-14	Date: 10/09/14	Date:	N/A
inspected to PA2 Dwg only		Revised by	Approved
Rev	Date	Change	
A		New Issue	KJ/JLM



PRELIMINARY ISSUE

D4173-7 RADALT SCHIM

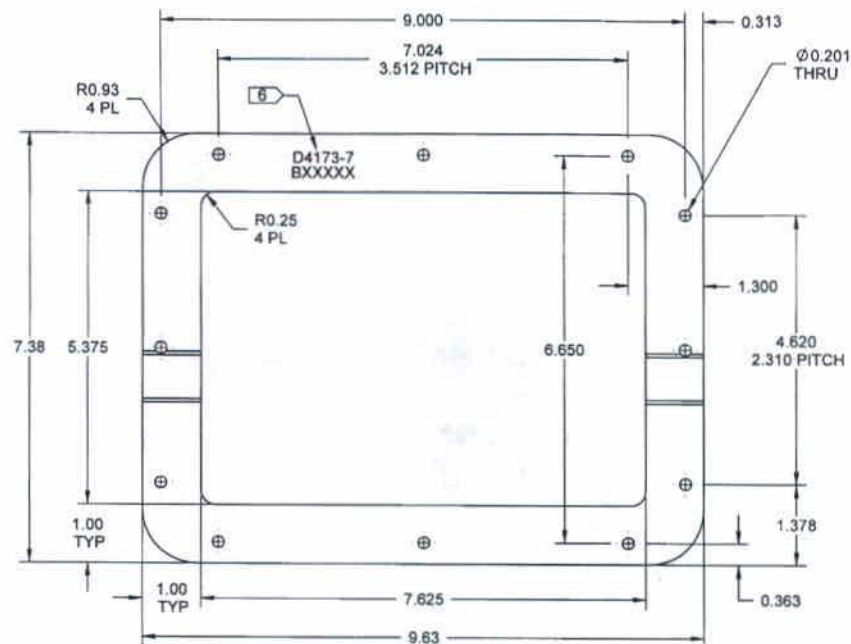
ALL DMS
OK WITH 2 DEC. PL.

10.09.15

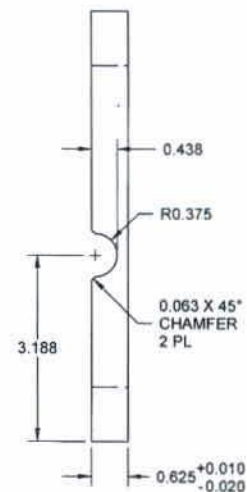
PRELIMINARY ISSUE
10.09.15

- NOTES**
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF: DART SPEC. MUHMWB
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.4
 - 7) WEIGHT: 0.76 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG APPR		D4173	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR		POD RADALT MOUNTING PLATE ASSY	NTS
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	



D4173-7 RADALT SHIM

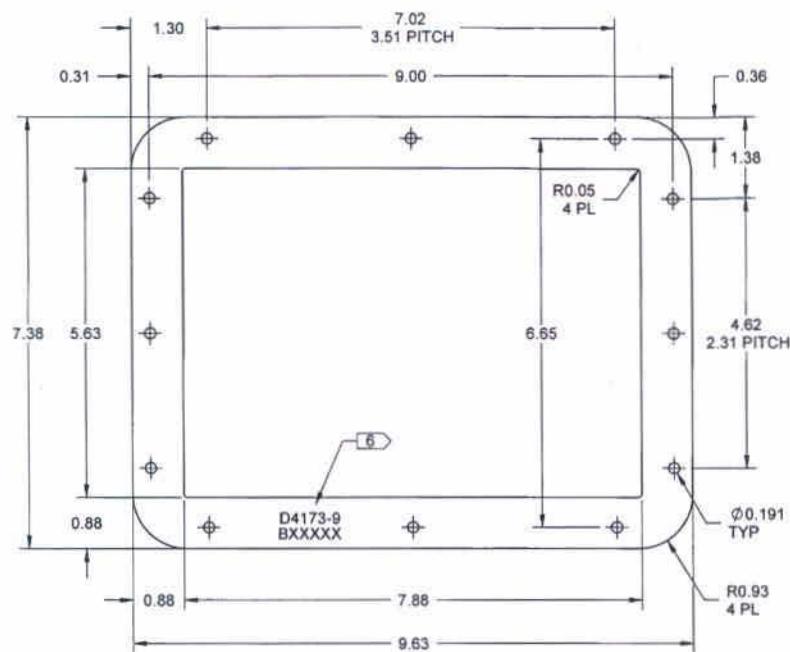


NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. DART SPEC. MUHMWB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.4
- 7) WEIGHT: 0.75 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4173	SHEET 7 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	POD RADALT MOUNTING PLATE ASSY NTS	
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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61969
RELEASED
2010-09-29
MR



D4173-9 POD RADALT SEAL

RELEASED
2010-09-29

NOTES:

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK
REF. DART SPEC. M-NEO60-S.0.63
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4173	REV. A
MFG. APPR.		TITLE	SHEET 8 OF 8
APPROVED		POD RADALT MOUNTING PLATE ASSY NTS	SCALE
DE APPR.			
DATE	10.09.01		

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